

Work Order ID 57961

April 21, 2010 9:19:18 AM



Page 1

Item ID: D206-642-541

Accept



Setup Start



Revision ID:

Item Name: Replacement Skidtube

Stop



Start Date: 21/04/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 28/04/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

BT

Date: 10-4-21

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3274

D

IIN-D206-642

Rev M

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPP D206-642-541

CHG003

N/A

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

110

0.00



Skidtubes

Skidtubes

Skidtubes

Memo

0.00

****VERIFY AND INSPECT THE MATERIAL PRIOR TO USE****

1- Bend FWD end of tube using bend prog D3274 FWD dwg D3274, cut fwd end of tube with saw table setup D3274.

DP 10-5-4

2- remove fwd indexing ridge as per dwg D3274. Prepare for welding

3- weld fwd cap as per dwg D3274 and QSI004

AR Aluminum Rod Batch: M112860/M112507

BE 10-5-5

4- grind fwd cap weld on top surface only

BE 10-5-5

5- Cut AFT end of tube at 170.9" as per dwg D3274 and deburr end.

6-Drill Aft cap pilot hole using DT8025

7 -Cleco DT8025 in position and install pilot hole drill Jig DT8742A,B,C,D.
Drill 3/16" pilot holes as per Dwg D3274

DP 10-5-11

8 -Remove inner indexing ridge on aft end of skidtube as per Dwg D3274 scribe batch #

9 -Open aft end cap holes to Ø0.208" as per Dwg D3274. Deburr aft end.

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00							
			DP						
					10-5-11				
130 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00							
			S 10/6/14						
140 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							
			S 10/6/14						
						(40)			

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150



Skidtubes

Skidtubes

0.00

Memo

0.00

1-Open Ø0.313" and 0.375" crossbolt spacer holes using DT8743 as per Dwg D3274

2-Deburr crossbolt spacer holes as per Dwg D3274 and blow out chips from inside the tube

3-Bond web in place as per Dwg D3274 & QSI 015.

A/R ☐ Sikaflex-291 ☒ 1113435 ☐

Sikaflex expire date: ☐ 10-11-30 ☐

Start: ☐ 10-5-11 ☐ Time: ☐ 2300PM

Finish: ☐ 10-5-13 ☐ Time: ☐ 7:30 AM

(Adhere for 12 hours)

[Handwritten signature] 10-5-11

160



QC

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Quality Control

① 0 BE 10-05-18

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Reference:

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

170

0.00



Skidtubes

Skidtubes

Memo

0.00

1-Bend AFT end of tube using bend prog. D3274 AFT as per dwg D3274. Install drop pins in crossbolt spacer holes to maintain web position.

11/12/15/18

2- DRILL PILOT HOLES FOR WEARPLATES USING D3274-1T2
OPEN HOLES TO .297" . Deburr

3-DRILL TOE PIN HOLE .640" DIA AS PER DWG USING DT8935 FWD
END OF TUBE
DEBURR INSIDE OF HOLE AS NECESSARY (DO NOT ENLARGE HOLES)
REMOVE ANY FOREIGN OBJECTS INSIDE OF TUBES

Q.M 10-05-18 @

4- Countersink crossbolt spacer holes as per Dwg D3274

5- prepare for welding

180



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

h23.0
L° = 4.9°

Subst 18

⊕

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	Skidtubes	0.00							
	Skidtubes								
	Skidtubes								
	Memo	0.00							
	1-Insert D2649 & D3275-1 crossbolt spacers. Weld as per QSI 004 and Dwg D3274. Remember to back drill each hole before welding the other side. Use aluminum rod A/R <input type="checkbox"/> Aluminum Rod <input checked="" type="checkbox"/> m112507								BE 10/05/18
	3-Grind cross bolt welds flush as per Dwg D3274.								11/05/19
	4-Counterbore 5/16" x 0.750" deep as per Dwg D3274 and deburr.								11/05/20
200	QC5- Inspect part completeness to step on W/O	0.00							
	QC								
	Quality Control								
	Memo	0.00							8/05/20

200



QC

Quality Control

Memo

0.00

8/05/20

EL

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

210



QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

Memo

0.00

5/05/20



220



HandFinish

Hand Finishing

Pressure Wash per QSI005 4.3

0.00

Memo

0.00

RE ALIGNED. PAR 09-043.

1 BL 10-5-25.

230



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

Memo

0.00

2104207

START TIME: 1:30pm
OVEN TEMPERATURE: 320°
FINISH TIME: 2:00pm

= 7/11 10/05/25

1 0

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Customer:

Reference:

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

240



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

S. W. 10/14/28

40

250



HandFinish

Hand Finishing

HandFinishing

0.00

Memo

0.00

1-Install Nut Plate as per Dwg D3274. Apply LPS-3 to Nut Plate and rivets.

A/R ☐ N/A ☐ LPS-3 ☐ *PROV 104251*

2-Install inserts as per Dwg D3274. Use a drop of Sikaflex inside insert holes a

A/R ☐ ☐ Sikaflex-291 ☐ *113835*

Sikaflex expire date: ☐ *10/11*

1 10-5-27.

260



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Inspect Nut Plate & Inserts

S. W. 10/15/28

40

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Cust Item ID:

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

270

0.00



HandFinish

HAND FINISHING RESOURCE #1

Memo

0.00

Hand Finishing

1-Install wearpads & gaskets as per Dwg D3274.

2-Install ring as per Dwg D3274

A/R ☐ Sikaflex-291 ☒ 11/13/35

Sikaflex expire date: ☐ 10/11

3-Inspect for foreign objects as per QSI 024

4-Spray inside of tube on both sides of web with LPS-3

A/R LPS-3 Batch: DR640W 104251

5-Install Aft Cap and seal with Sikaflex. Clean excess adhesive.

A/R ☐ Sikaflex-291 ☒ 11/13/35

Sikaflex expire date: ☐ 10/11

① 10-5-28

280

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8/10/05/79

10

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Cust Item ID:

Required Date: 28/04/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

290



Packaging

Identify as per dwg & Stock Location: _____

0.00

Memo

PM
57369

0.00

Packaging

300



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

MF 10-5-31

Picklist Print

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Page 1

Work Order ID: 57961



Parent Item: D206-642-541



Parent Item Name: Replacement Skidtube

Start Date: 21/04/2010

Required Date: 28/04/2010

Comments:

IPP Rev:B 05.09.23 Revised per D206-642 Rev. J KJ/JLM
IPP Rev:C 07-02-23 Added SS Wearplates & Gaskets JLM
IPP Rev:D 07-12-06 replace NAS1515H3L to D3672-1 DD
IPP Rev:E 08-04-17 as per PAR 08-015 DD verified by:EC

Start Qty: 1.00

Required Qty: 1.00

D2600-1-190

Manufactured No

110

Each

44.0000

1.0000



Extrusion Round 3" 206



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

LG

47575

110

Each

158.0000

1.0000

D3285-1

Manufactured No



Cap



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

LG

47635

52511

52647

158

9

74

75

150

Each

0.0000

1.0000

D3282-041

Manufactured No



Float Web (206L/407)

D2649

Manufactured No



Cross Bolt Spacer



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

LG

55000

85

85

258545

x 12

BE 10/05/18

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Start Date: 21/04/2010

Required Date: 28/04/2010

Comments: IPP Rev:B 05.09.23 Revised per D206-642 Rev. J KJ/JLM
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 IPP Rev:D 07-12-06 replace NAS1515H3L to D3672-1 DD
 IPP Rev:E 08-04-17 as per PAR 08-015 DD verified by:EC

Start Qty: 1.00

Required Qty: 1.00

D3275-1 Manufactured No 190 Each 20.0000 12.0000



Crossbolt Spacer



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

LG

53453

358179 * 12 BE 10/05/18

20

20

CR3212-4-03

Purchased No

250 Each 2,117.000 2.0000



Cherry Rivet



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST311

111359 ✓

112314

114436

2117

92

125

1900

2 BR 10-5-28

D3415-041

Manufactured No

250 Each 75.0000 1.0000



Nut Plate



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST056

33842 ✓

75

75

1 BR 10-5-28.

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IPP Rev:E 08-04-17 as per PAR 08-015 DD verified by:EC

Start Qty: 1.00

Required Qty: 1.00

CCR264SS3-3

Purchased

No

250

Each

724.0000

2.0000



Cherry Rivet

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST311

724

111548

4

112314

4

113539

92

113973 ✓

624

ALS4-1032-130

Purchased

No

250

Each

1,912.000

78.0000



Insert

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST282

1912

110511

40

114407

1872

2 Bl 10-5-28

78 Bl 10-5-28.

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IPP Rev:E 08-04-17 as per PAR 08-015 DD verified by:EC

Start Qty: 1.00

Required Qty: 1.00

D3536-15

Manufactured No

270

Each

19.0000

1.0000



Gasket

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP

19

51600

7

56055 ✓

12

D3536-23

Manufactured No

270

Each

16.0000

1.0000



Gasket

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP

4

53468

4

Main Warehouse

FP011

12

57529 ✓

12

1 BR 10-5-28

1 BR 10-5-28.

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Start Qty: 1.00

Required Qty: 1.00

D3536-35

Manufactured No

270

Each

18.0000

1.0000



Gasket

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP

58637

6

51628

6

Main Warehouse

FP012

12

57530

12

D3536-39

Manufactured No

270

Each

11.0000

1.0000



Gasket

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP

11

48161

1

51637 ✓

10

1 BR 10-5-08

1 BR 10-5-08

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Start Date: 21/04/2010

Required Date: 28/04/2010

Start Qty: 1.00

Required Qty: 1.00

D3535-15 Manufactured No 270 Each 14.0000 1.0000



Wearshoe

Warehouse Loc Qty Loc Code
Location

Main Warehouse

FP 14

53462 4

56053 10

D3535-35 Manufactured No 270 Each 16.0000 1.0000



Wearshoe

Warehouse Loc Qty Loc Code
Location

Main Warehouse

FP 5

51608 5

Main Warehouse

FP018 11

57528 11

1 BL 10-5-28

1 BL 10-5-28

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Start Date: 21/04/2010

Required Date: 28/04/2010

Start Qty: 1.00

Required Qty: 1.00

D3535-39

Manufactured No

270

Each

9.0000

1.0000



Wearshoe



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP

51619 ✓

9

9

D3535-23

Manufactured No

270

Each

24.0000

1.0000



Wearshoe



1 PR 10-5-28

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP

11

53467

1

56054

10

Main Warehouse

FP21

13

57730 ✓

13

1 PR 10-5-28

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Start Qty: 1.00

Required Qty: 1.00

D3537-3 Manufactured No 270 Each 24.0000 1.0000



Wearpad



Warehouse Loc Qty Loc Code
Location

Main Warehouse

FP 2

35697 2

Main Warehouse

FP17 22

57512 ✓ 22

D3537-1 Manufactured No 270 Each 51.0000 9.0000



Wearpad



Warehouse Loc Qty Loc Code
Location

Main Warehouse

FP 57713 9

55465 9

Main Warehouse

FP17 42

57510 42

AN960C10L Purchased No 270 Each 0.0000 80.0000



washer

NAS 1149C0332R

114341 ✓



80 BK 10-5-28

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 IPP Rev:E 08-04-17 as per PAR 08-015 DD verified by:EC

Start Qty: 1.00

Required Qty: 1.00

AN960C416

Purchased No

270 Each

376.0000 1.0000



washer



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST346

376

100993 ✓

376

D3672-1

Manufactured No

270 Each

1,581.000 2.0000



Phenolic Washer



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST077

1581

47628

81

51674 ✓

500

52505

1000

1 BR 10-5-08

2 BR 10-5-08

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 IPP Rev:C 07-02-23 Added SS Wearplates & Gaskets JLM
 IPP Rev:D 07-12-06 replace NAS1515H3L to D3672-1 DD
 IPP Rev:E 08-04-17 as per PAR 08-015 DD verified by:EC

Start Qty: 1.00

Required Qty: 1.00

AN3C4A Purchased No 270 Each 1,799.000 80.0000



BOLT

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST350 114523	1799	
114103	501	
114108	300	
114330	498	
114416	500	

80. BR 10.5.28

AN4C5A Purchased No 270 Each 533.0000 1.0000



BOLT

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST346	533	
110552 ✓	33	
112243	500	

1 BR 10.5.28.

Picklist Print

April 21, 2010 9:19:22 AM

Page 11

Work Order ID: 57961



Parent Item: D206-642-541



Parent Item Name: Replacement Skidtube

Start Date: 21/04/2010

Required Date: 28/04/2010

Comments: IPP Rev:B 05.09.23 Revised per D206-642 Rev. J KJ/JLM
 IPP Rev:C 07-02-23 Added SS Wearplates & Gaskets JLM
 IPP Rev:D 07-12-06 replace NAS1515H3L to D3672-1 DD
 IPP Rev:E 08-04-17 as per PAR 08-015 DD verified by:EC

Start Qty: 1.00

Required Qty: 1.00



D2646 Manufactured No 270 Each 32.0000 1.0000



Warehouse Loc Qty Loc Code
Location

Main Warehouse

FP6 57832 ✓ 28
 52663 28

Main Warehouse

fp7 4
 52663 4

1 Bl 10-5-08

D3413-1



Ring

Manufactured No 270 Each 31.0000 1.0000



Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST473 58524 31
 51586 8
 53446 23

1 bl 10-5-08.

DART

DESIGN CP	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3274	REV. D SHEET 1 OF 4
DATE 06.12.19		TITLE SKIDTUBE ASSEMBLY SCALE NTS	
A	04.03.15	NEW ISSUE	
B	04.08.09	MOVE SADDLE HOLE: 42.14 WAS 42.76	
C	05.03.16	ADD -043; NEW INSERTS	
D	06.12.19	NEW INSERTS, SS WEARSHOE + GASKET	

RELEASED07.02.12 **[Signature]****DEO ATTACHED**

Qty -041	Qty -043	Part Number	Description
X		D3274-041	SKIDTUBE ASSEMBLY
	X	D3274-043	SKIDTUBE ASSEMBLY
1	1	D2600-1-240	EXTRUSION
1	1	D2646	AFT CAP
12	12	D2649	CROSS BOLT SPACER
12	37	D3275-1	CROSS BOLT SPACER
1	1	D3282-041	FLOAT WEB
1	1	D3285-1	CAP
1	1	D3413-1	RING
1	1	D3415-041	NUT PLATE
1	1	D3535-15	WEARSHOE
1	1	D3535-23	WEARSHOE
1	1	D3535-35	WEARSHOE
1	1	D3535-39	WEARSHOE
1	1	D3536-15	GASKET
1	1	D3536-23	GASKET
1	1	D3536-35	GASKET
1	1	D3536-39	GASKET
9	9	D3537-1	WEARPAD
1	1	D3537-3	WEARPAD
78	78	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)
80	80	AN3C4A	BOLT
1	1	AN4C5A	BOLT
1	1	AN960C416	WASHER
80	80	AN960C10L	WASHER
2	2	CCR264SS3-3	RIVET
2	2	CR3212-4-03	RIVET
2	2	NAS1515H3L	WASHER

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SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

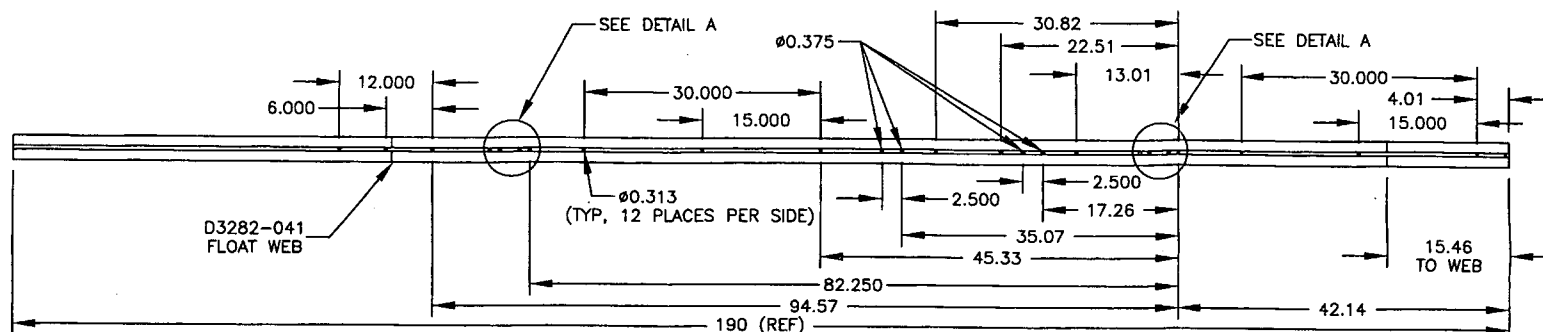
NO **5796** GENERAL NOTES:

1. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
2. DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 7 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
3. ALL HOLES DRILLED ON CENTERLINES.
4. BOND D3282-041 FLOAT WEB INTO D3274-1/-3 OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/291 ADHESIVE PER DART QSI 015. ENSURE HOLES LINE-UP.
5. WELDING TO BE DONE PER DART QSI 004.
6. FINISH: - ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1
- POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
7. DRILL Ø0.297 HOLES FOR ALS7-1032-130 INSERTS USING DT3274-1T2 BEFORE FINISH. INSTALL ALS7-1032-130 INSERTS AFTER FINISH. SEAL WEARSHOE BOLTS WITH SIKAFLEX -241/-291.
8. SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.

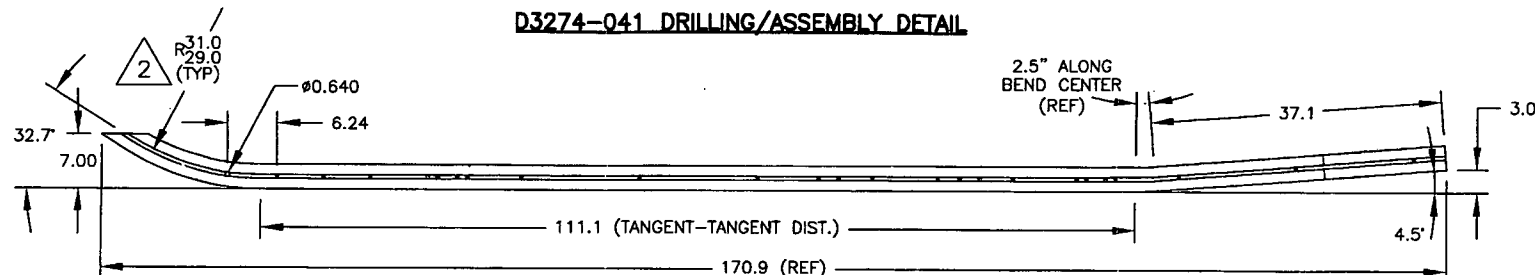
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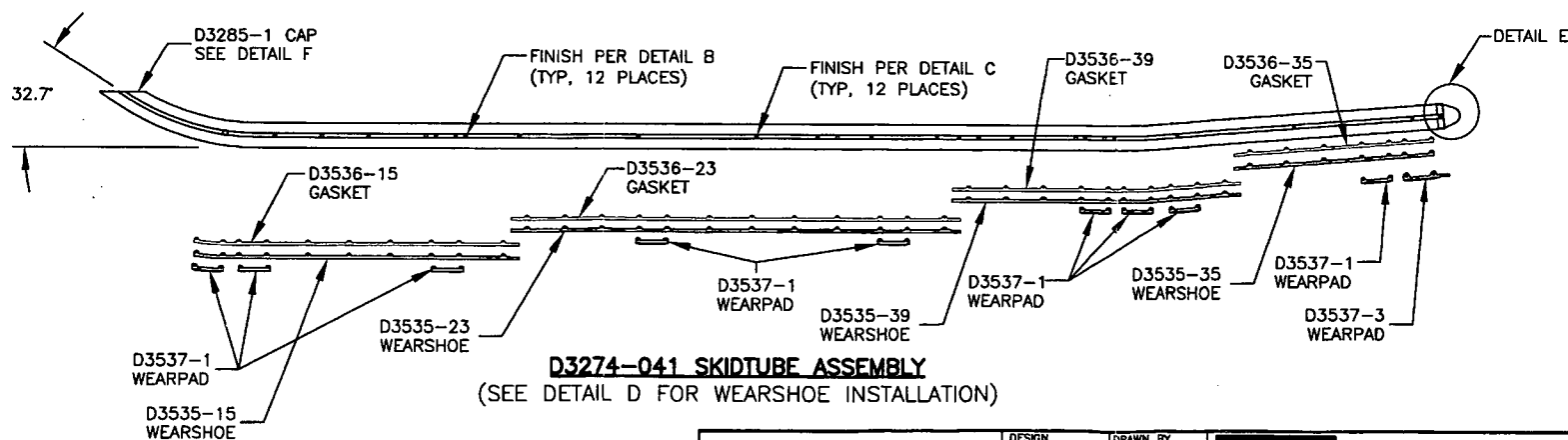
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D3274-041 DRILLING/ASSEMBLY DETAIL



D3274-041 BEND/DRILLING DETAIL



D3274-041 SKIDTUBE ASSEMBLY
(SEE DETAIL D FOR WEARSHOE INSTALLATION)

RELEASED

07.02.12

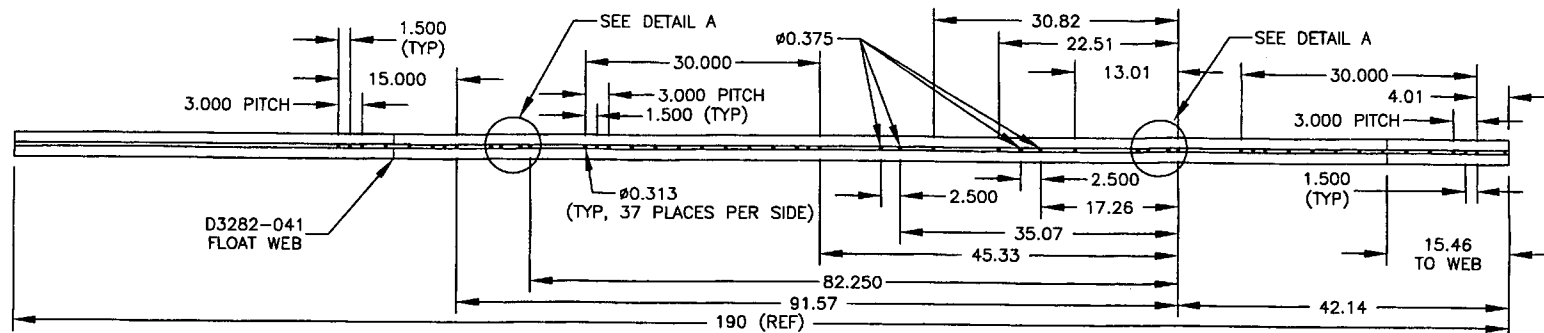
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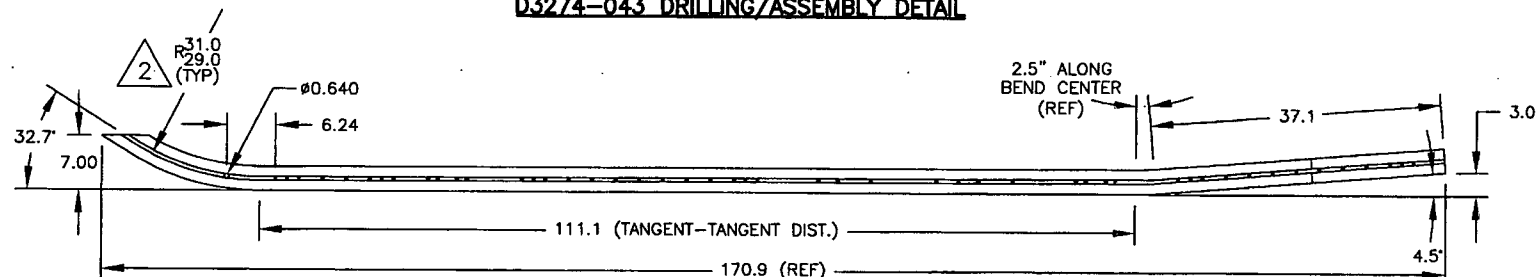
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DESIGN	CP	DRAWN BY	PH	DART	DART AEROSPACE USA, INC.
CHECKED	#	APPROVED	#	D3274	REV. D
DATE	06.12.19	TITLE	SKIDTUBE ASSEMBLY	SHEET 2 OF 4	SCALE
					1:15

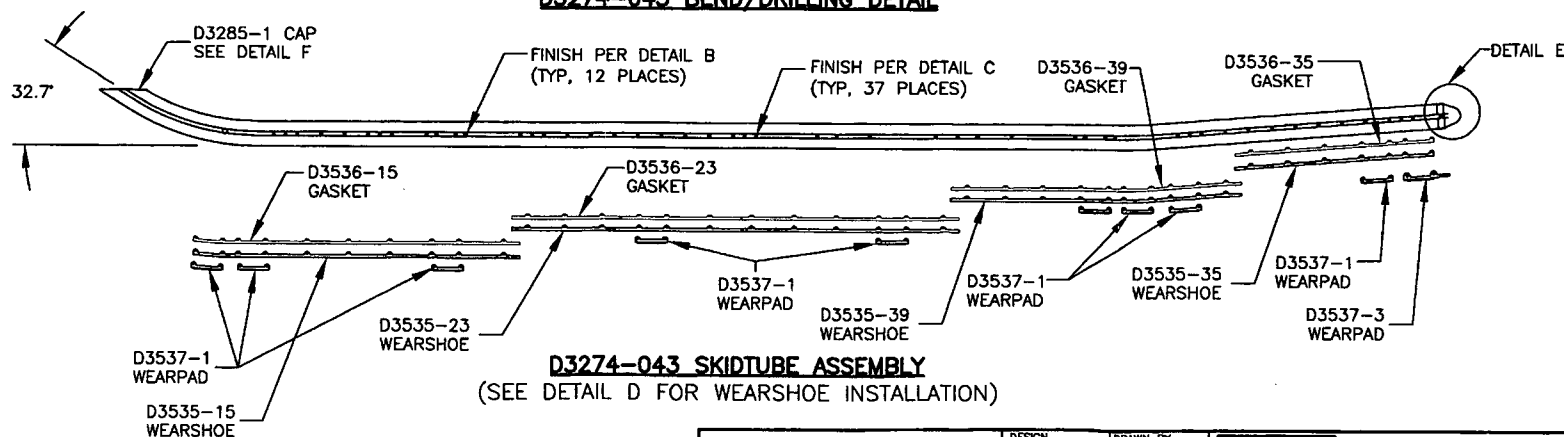
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D3274-043 DRILLING/ASSEMBLY DETAIL



D3274-043 BEND/DRILLING DETAIL



D3274-043 SKIDTUBE ASSEMBLY
(SEE DETAIL D FOR WEARSHOE INSTALLATION)

RELEASED

07.02.12

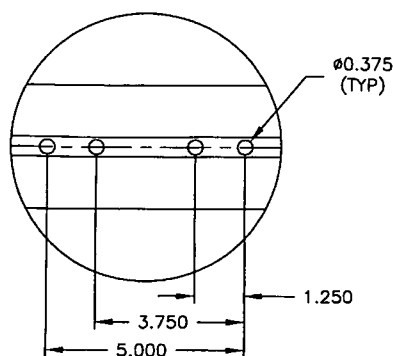
W6 57961

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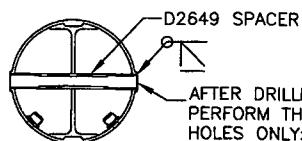
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DESIGN	CP	DRAWN BY	PH	DART DART AEROSPACE USA, INC. PORT PADLOCK, VA
CHECKED	#	APPROVED	#	DRAWING NO. D3274
DATE	06.12.19	TITLE	SKIDTUBE ASSEMBLY	REV. D SHEET 3 OF 4 SCALE 1:15

DETAIL A: DRILL DETAIL

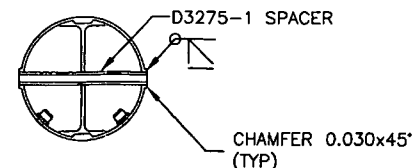


DETAIL B FOR 0.375 HOLES ONLY

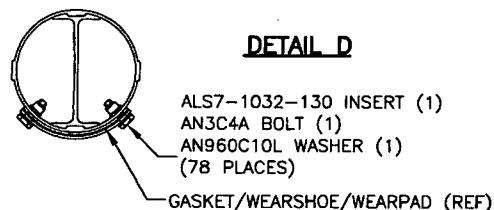


- AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR 0.375
HOLES ONLY:
1. CHAMFER HOLE 0.030x45°
 2. INSERT D2649 SPACER
 3. WELD INTO PLACE AND GRIND FLUSH
 4. C'BORE TO 0.313x0.75 DEEP

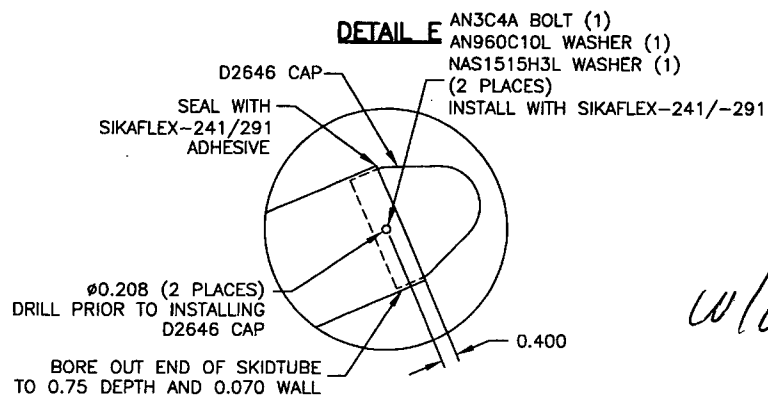
DETAIL C FOR 0.313 HOLES ONLY



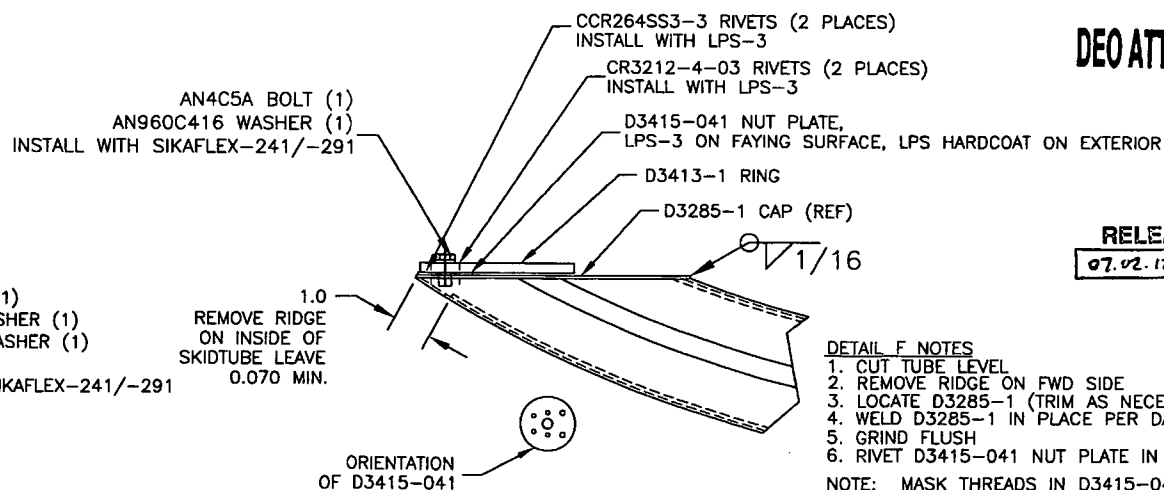
DETAIL D



DETAIL E



DETAIL F: END FINISHING DETAIL



DEO ATTACHED

RELEASED
07.02.12

- DETAIL F NOTES**
1. CUT TUBE LEVEL
 2. REMOVE RIDGE ON FWD SIDE
 3. LOCATE D3285-1 (TRIM AS NECESSARY)
 4. WELD D3285-1 IN PLACE PER DART QSI 004
 5. GRIND FLUSH
 6. RIVET D3415-041 NUT PLATE IN PLACE
- NOTE: MASK THREADS IN D3415-041
PRIOR TO FINISH

w/057961

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DATE 06.12.19		TITLE SKIDTUBE ASSEMBLY		REV. D SHEET 4 OF 4 SCALE 1:3

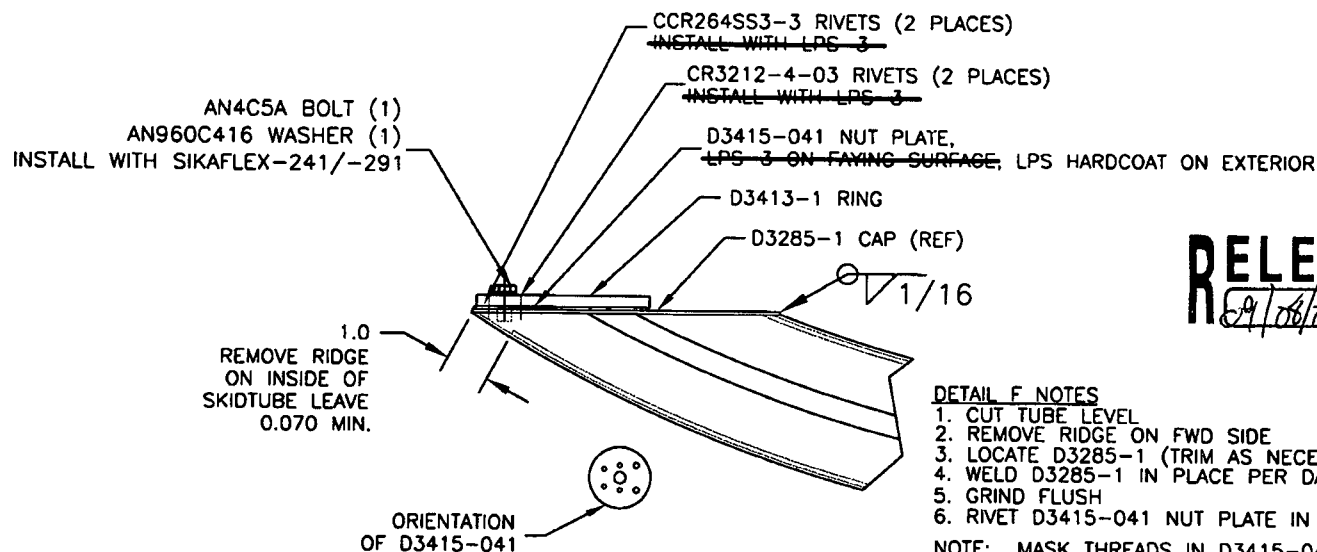
DRAWING NO. D3274	TITLE SKIDTUBE ASSEMBLY	REV. D	DART AEROSPACE USA, INC ENGINEERING ORDER		D.E.O. NO. D3274-D-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>CP</i>	CHECKED <i>1</i>	MFG. APPR. <i>M</i>	APPROVED <i>JAP</i>		DE APPR. <i>#</i>		
DATE 09.06.17	DATE 09.06.23	DATE 09/06/23	DATE 09/06/23		DATE 09.06.23		

LPS-3 IS NO LONGER USED DURING ASSEMBLY OF SKIDTUBE.

AMEND NOTE 8: ~~"SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES 'LPS 3' AFTER FINISH AND INSTALLATION OF INSERTS.~~
COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES 'LPS PROCYON' AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF
POWDER COATING WITH MEK DEGREASER."

AMEND DETAIL F AS SHOWN:

DETAIL F: END FINISHING DETAIL



RELEASED
09/06/23

DETAIL F NOTES

1. CUT TUBE LEVEL
2. REMOVE RIDGE ON FWD SIDE
3. LOCATE D3285-1 (TRIM AS NECESSARY)
4. WELD D3285-1 IN PLACE PER DART QSI 004
5. GRIND FLUSH
6. RIVET D3415-041 NUT PLATE IN PLACE

NOTE: MASK THREADS IN D3415-041
PRIOR TO FINISH

w/o 57961

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NO 230

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job number: 57358
Part number: DAC6-642-541
Description: Heat tube
Welding Process: Tig[☒] Mig[]
Base material: Aluminium
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[]
Penetration: pass[☒] fail[]

UNACCEPTABLE

Cracks: pass[☒] fail[]
Undercut: pass[☒] fail[]
Pin holes: pass[☒] fail[]
Overlap (cold lap): pass[☒] fail[]
Porosity (surface): pass[☒] fail[]
Coloration: pass[☒] fail[]

Qualifier Rat. Phil Date of Test Coupon 10.05.05

Welder Barclay Elliott Date of Test Coupon 10-05-05

The above named individual is qualified in accordance with AWS D17.1.2001 to weld